

86902

July-09-12 10:34:21 AM

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 7/09/12 **Start Qty:** 8.00

8

Cust Item ID:

Required Date: 8/10/12 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: **Process Plan:**

Date: 12-07-10

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):**Date:**

Stop *NR2*

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86902

86902

Page 2

July-09-12 10:34:21 AM

Item ID: D3371-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Pedal Lock Base
 Start Date: 7/09/12 Start Qty: 8.00 *8* Cust Item ID:
 Required Date: 8/10/12 Req'd Qty: 8.00 *8* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									

140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									

145	Fire Red(Ref:4.3.5.10) per QSI005 4.3	0.00							
145									
Powdercoat	Memo	0.00							
Powder Coating	POWDER COAT: 9:20 Start Time: 320 OF Oven Temperature: 320 OF Finish Time: 9:50								

M113645

Exp 12/08/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 86902

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Page 3

Item ID: D3371-1 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Pedal Lock Base
Start Date: 7/09/12 Start Qty: 8.00 *8* Cust Item ID:
Required Date: 8/10/12 Req'd Qty: 8.00 *8* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									
160	Identify as per dwg & Stock Location: 490 A	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

12-08-14

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July-09-12 10:34:21 AM

Page 1

Work Order ID: 86902

Parent Item: D3371-1

Parent Item Name: Pedal Lock Base

Start Date: 7/09/12

Required Date: 8/10/12

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP A05.01.18New issueKJ/JLMIPP RevB: add powdercoat DD 10.01.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X02.250 6061-T6 Bar 2.00 x 2.25		Purchased	No			100	f	20.1240	0.625	5.2631576			

Location

Loc Qty

Loc Code

MAT009

8.124

118072

1.456

119513

6.668

MAT050

12

122245

12

122521

FK 12/08/09

5.264

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	PC902
Description: Pedal Lock Base		Part Number:	D3371-1
Inspection Dwg: D3371	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
60°	+/-0.5°	60°	✓		Angle Meter	CNC-03
2.25	+/-0.030	2.247	✓		Vern	GA-01
1.650	+/-0.010	1.650	✓		D-6	GA-08
1.648	+/-0.010	1.649	✓		Vern	GA-01
0.700	+/-0.010	0.700	✓		D-6	GA-08
3.955	+/-0.010	3.955	✓		Vern	GA-01
0.600	+/-0.010	0.600	✓		H-6	31006
0.104	+/-0.010	0.104	✓		Vern	GA-01
0.305	+/-0.010	0.302	✓		"	"
45°	+/-0.5°	45°	✓		Angle Meter	CNC-03
0.672	+/-0.010	0.669	✓		Vern	GA-01
Ø1.300	+/-0.010	Ø1.300	✓		"	"
1.450	+/-0.005	1.450	✓		Vern	GA-01
7°	+/-0.5°	7°	✓		Angle Meter	CNC-03
2.00	+/-0.030	2.000	✓		Vern	GA-01
1.125	+/-0.010	1.123	✓		"	"
Ø1.125	+/-0.010	Ø1.125	✓		"	"
R0.500	+/-0.010	R0.500	✓		R-6	ref.
1.000	+/-0.010	1.000	✓		Vern	GA-01
0.375	+/-0.010	0.375	✓		"	"
Ø0.203	+0.005/-0.000	Ø0.204	✓		"	"
7.19	+/-0.030	7.187	✓		Vern	CNC-07
4.500	+/-0.010	4.500	✓		Vern	GA-01
0.500	+/-0.010	0.500	✓		"	"

Measured by:	JA	Audited by:	Re	Prototype Approval:	N/A
Date:	12/08/12	Date:	12.8.13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	
B	05.05.25	Revised dimensions	KJ/JLM	

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

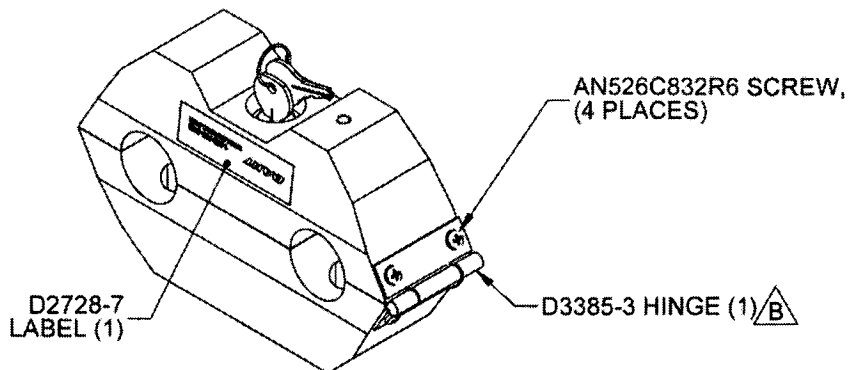
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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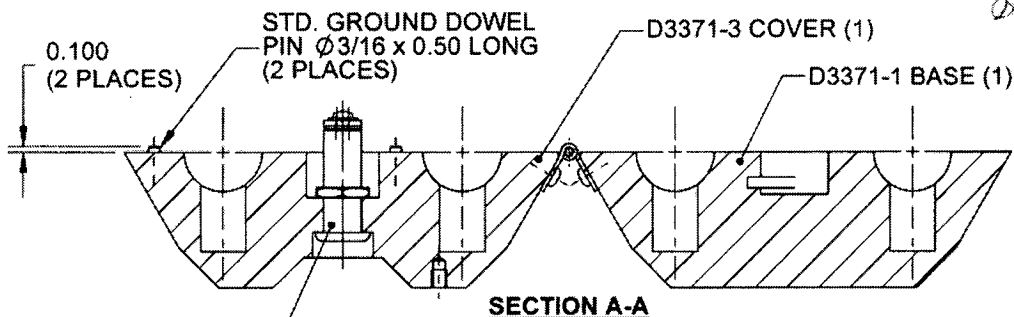
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 1 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:3
A	04.12.06	NEW ISSUE	
B	05.03.22	D3385-3 WAS D3385-1	

86902
RL 120710



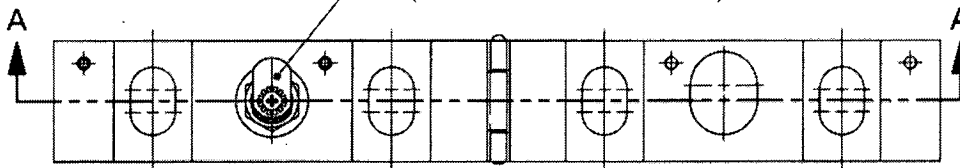
PEDAL LOCK SHOWN LOCKED WITH KEY

RELEASED
[Signature]
05/04/28



D3373-7 CAM
LOCK ASS'Y

D3371-5 CAM (1),
AND SQUARE WASHER SPACER (1),
EXTERNAL TOOTH LOCK WASHER (1),
#10-32 UNF PAN CROSS HEAD SCREW (1)
(AS PER D3373 DRAWING)



D3371-051 PEDAL LOCK ASSEMBLY

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

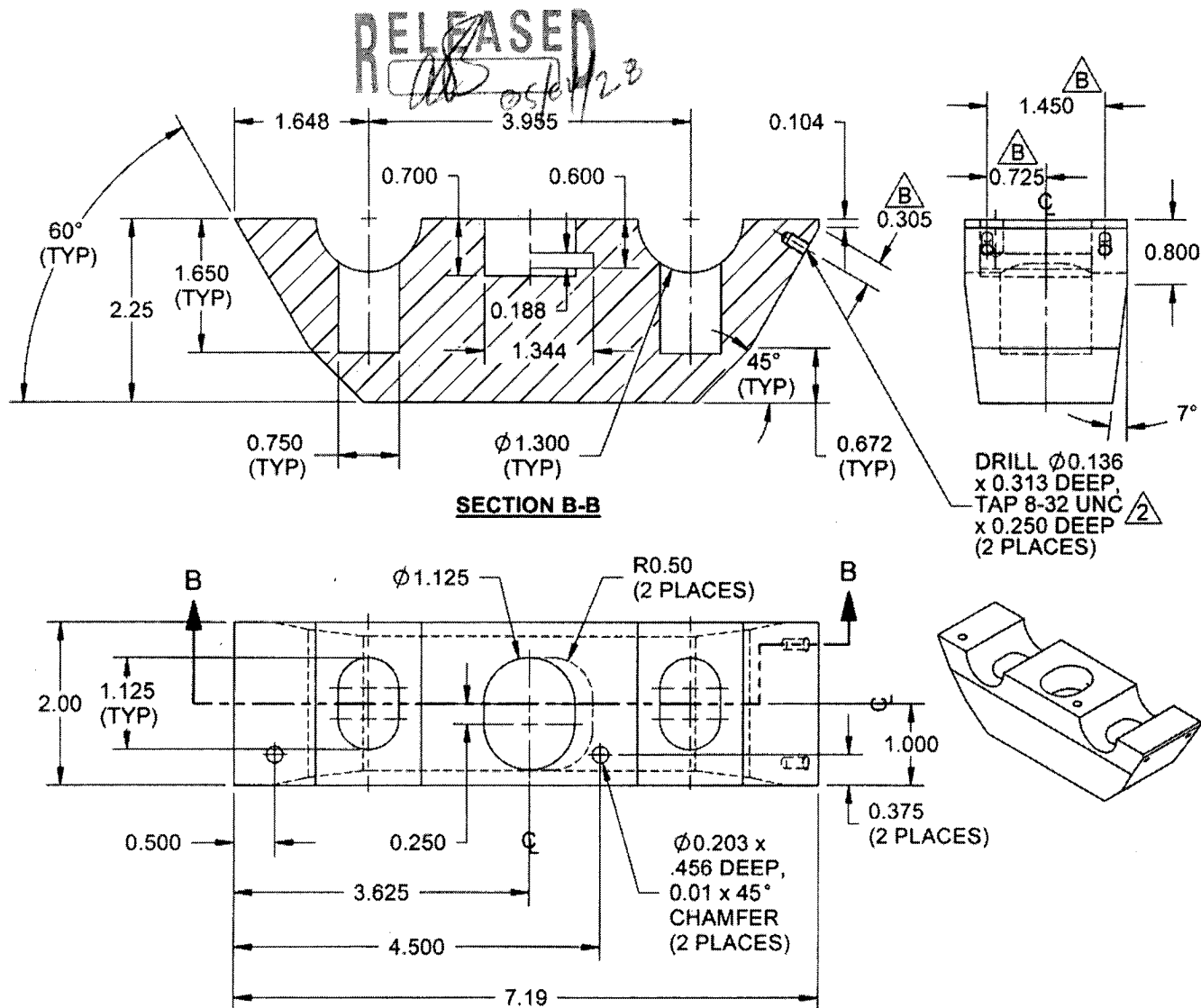
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NOTE: Date & initial all entries



DESIGN 43	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 7	APPROVED [Signature]	DRAWING NO. D3371	REV. B SHEET 2 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:2



NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Dart Aerospace Ltd

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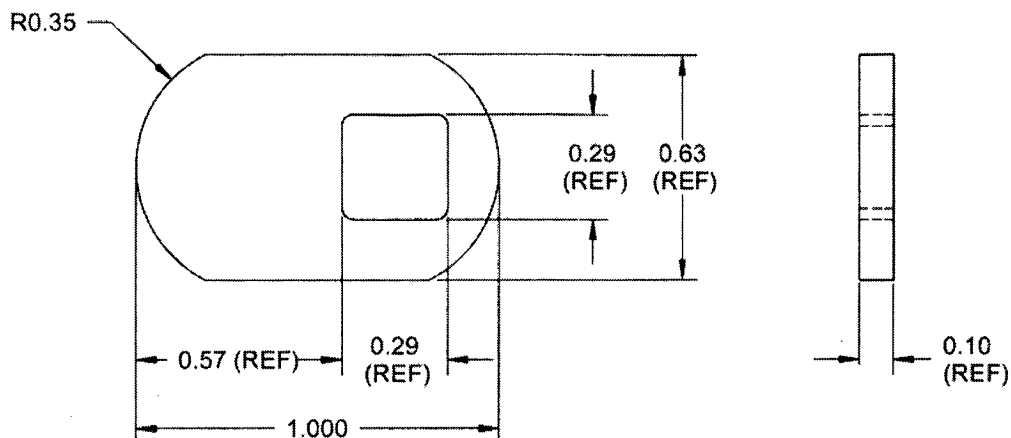
86907



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 4 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 2:1

RELEASED
[Signature]
05/04/28

SPECIFICATION CONTROL DRAWING



D3371-5 CAM

NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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